

Date: Monday, 1/14/2008 2:37:10 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STOP
Job Number : 36749A	
Estimate Number : 10731	
P.O. Number :	Part Number : D23243
This Issue : 1/14/2008 S.O. No. :	Drawing Number : D2324 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : C
Previous Run : 35930A	Material :
Written By :	Due Date : 2/20/2008
Checked & Approved By : <u>JA 08/01/15</u>	Qty: 20 Um: Each
Comment : Est: E 03.02.28 Reformat, Incorporated D2324-3 & D2324-5 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
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Comment: Qty.: 0.5565 f(s)/Unit Total: 11.1300 f(s)
6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)
(M6061T6B0.750x00.750) Batch: M106563 x12pcs M102476 x9pcs

J.F. 08/02/11 (21)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: (0.75" x 0.75") x 5.75" Long Bar

J.F. 08/02/11 (21)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio D2324-3 and Dwg D2324
2- Deburr and Tumble to remove sharp edges
Identify as D2324-3

N/A

H.A./m 08/02/13 (20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A./m 08/02/13 (20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/02/15 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 28/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL 08-02-15

(20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

BL 08-02-15

(20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 26

AS 08/02/19

(20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/20

Job Completion



mi 2008/2/19 (20)

U

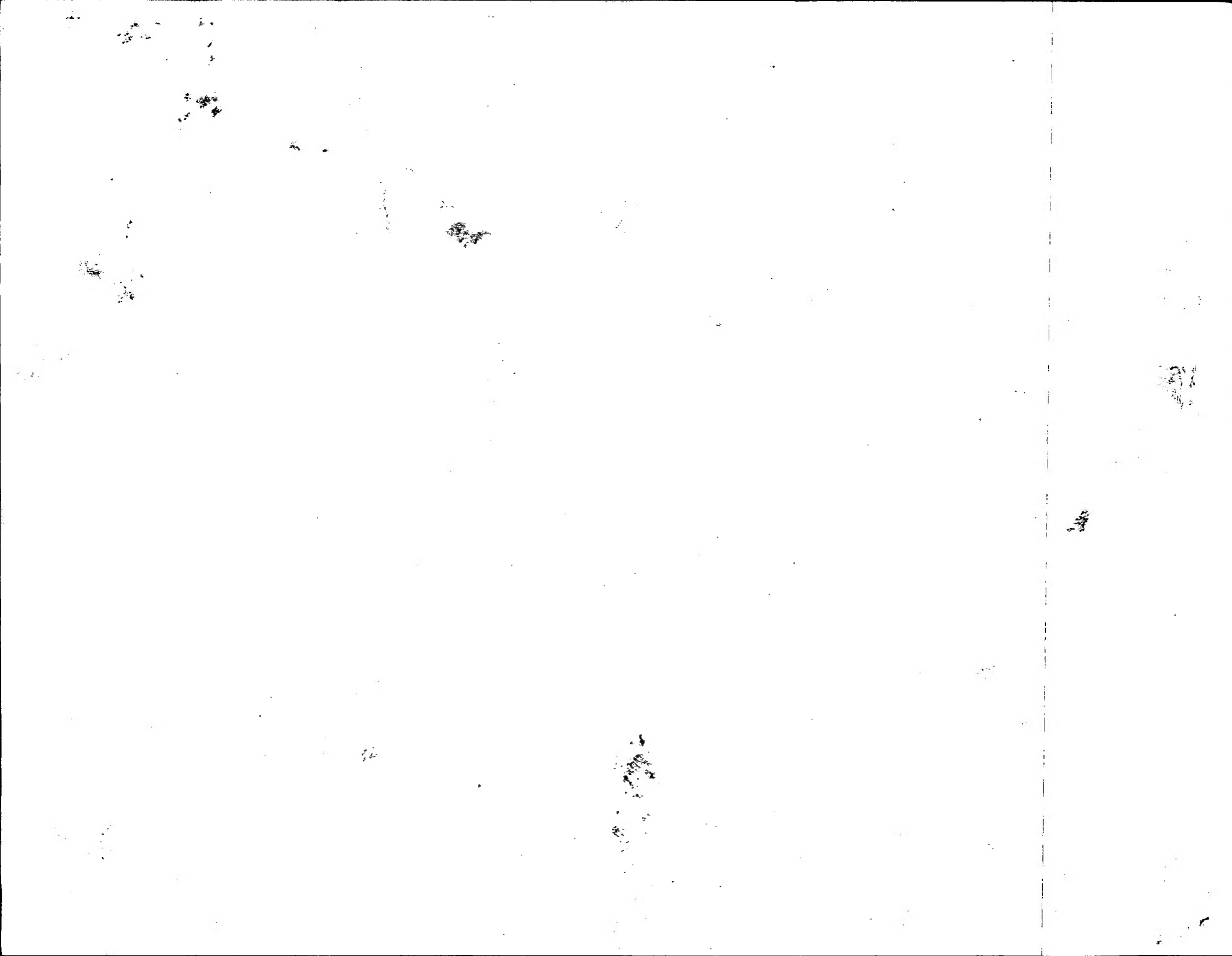
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

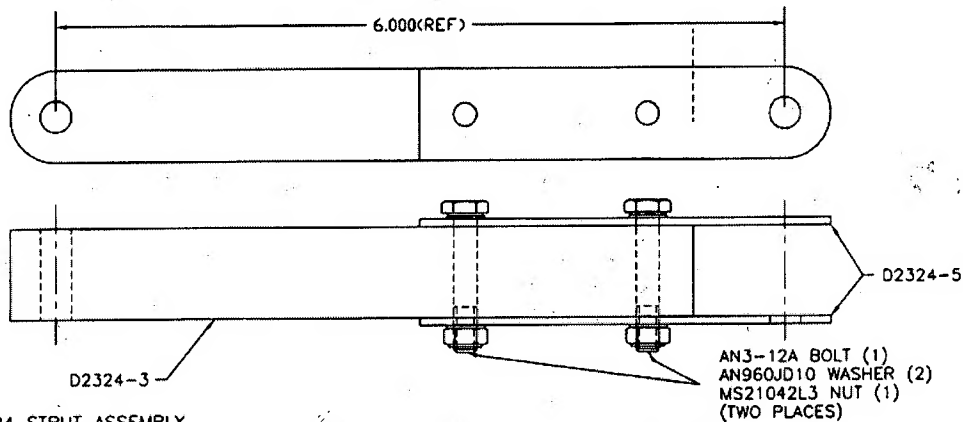




DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14		TITLE STRUT	SCALE
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

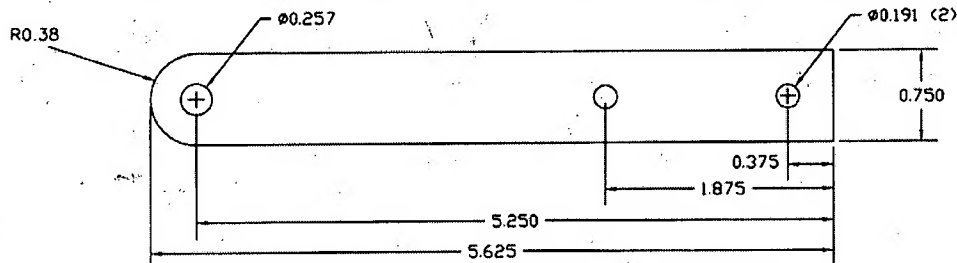
RELEASED

04.12.16 #



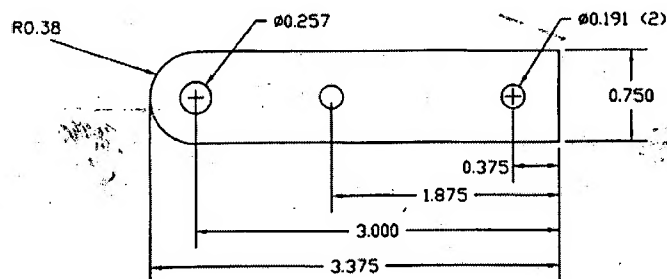
D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36749A

